



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4072-1

Job Sheet 187450



Part No: D4072-1

Job Qty: 10 ea 20

Part Name: Airframe Hinge



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/4/18

Job Tracking No:

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEET 1 Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD IPP REV:B DRAWING REV.
CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/25/19	1/25/19	0.00	0.00	Start Up Machining-2		DAS 19/01/07
100	Bandsaw	10 pcs	1/25/19	1/25/19	0.00	0.15	Bandsaw1		52
105	CNC Vertical Machining	10 pcs	1/25/19	1/25/19	0.20	4.44	HAAS1-4		9-89
110	QC	10 pcs	1/25/19	1/25/19	0.00	0.00	QC2 Machining-2		
120	QC	10 pcs	1/25/19	1/25/19	0.00	0.00	QC8 Machining-2		
150	HandFinish	10 pcs	1/25/19	1/25/19	0.00	0.18	HandFinish1		
160	Powdercoat	10 pcs	1/25/19	1/25/19	0.00	0.18	Powdercoat2		
170	QC	10 pcs	1/25/19	1/25/19	0.00	0.00	QC3		
180	Packaging	10 pcs	1/25/19	1/25/19	0.00	0.00	Packaging3-2		
190	QC21-SA	10 Ea	1/25/19	1/25/19	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.500	6061-T6 Bar 1.00 X 2.50	1.0400 ft (.104 ea)	90-Start up Operation	FM137365

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X02.500	1	11	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____		Part No. _____		Date : _____		Sequence # _____		Description Work Order Deviation _____	
DISPOSITION		Part: D4072-1 Job No: 187450 Serial No/Batch: S142126 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's		DEPARTMENT/PROCESS Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up		☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	
		Other/Details: _____							

DART AEROSPACE LTD		Work Order: 157450
Description: Airframe Hinge		Part Number: D4072-1
Inspection Dwg: D4072	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500 x 0.125	+/-0.010	Ø.500x.125	✓		GP+Ver	
2.00	+/-0.030	2.00	✓		Ver	
Ø0.203	+0.005/-0.001	0.203	✓		G.P	
0.750	+/-0.010	0.753	✓		Ver	
R0.06	+/-0.030	R0.06	✓		R.G.	
0.45	+/-0.030	0.45	✓		Ver	
1.100	+/-0.010	1.100	✓		Ver	
R0.38	+/-0.030	R0.38	✓		R.G.	
0.375	+/-0.010	0.376	✓		Ver	
0.688	+/-0.010	0.687	✓		Ver	
0.275	+/-0.010	0.275	✓		G.P.	
R0.13	+/-0.030	R0.13	✓		R.G.	
0.25	+/-0.030	0.249	✓		Ver	
1.06	+/-0.030	1.06	✓		Ver	
0.125	+/-0.010	0.125	✓		Ver	
0.86	+/-0.030	0.863	✓		H.G.	
Ø0.323	+0.005/-0.001	Ø.323	✓		G.P	

Measured by: DAS 52	Audited by: [Signature]	Preliminary Approval:
Date: 19/01/06	Date: 19/01/07	Date:

Rev	Date	Change	Revised by	Approved
A	11.06.26	New Issue	KJ	[Signature]
B	11.10.13	Dimension 0.25 removed	KJ	[Signature]